

SPLIT

Date: Wednesday, 11/03/2009 12:58:50 PM
User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SADDLE FITTING, FWD (OUTBOARD/INBOARD)
Job Number	: 46433 -1	Part Number	: D2572
Estimate Number	: 10531	Drawing Number	: D2572 REV E
P.O. Number	:	Project Number	: N/A
This Issue	: 11/03/2009 S.O. No. :	Drawing Revision	: E
Prsht Rev.	: NC	Material	:
First Issue	: 11 Type : MACHINED PARTS	Due Date	: 04/04/2009
Previous Run	: 45922	Qty:	12 Um: Each
Written By	:		
Checked & Approved By	: <u>J.D. 09.03.11</u>		
Comment	: Est: 1 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572KJ		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D6101005	Saddle Billet
Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s) 7075-T7351 8.25X5.0X2.5 Make from D6101-005 billet for D2572 Ensure that grain is along 5.00" length Batch No: <u>B34874</u>		
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
Comment: HAAS CNC VERTICAL MACHINING #1 Program Batch No: <u>46433</u> Double check by: <u>mmf</u> 1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets 4-Deburr and remove all machining marks 5-Tumble to remove shap edges.		
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
Comment: CONVENTIONAL MILLING MACHINE Machine keyway as per dwg D2571 & D2572		

J.L mmf 09/04/09

J.L mmf 09/04/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 11/03/2009 12:58:50 PM
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Customer: CU-DAR001 Dart Helicopters Services

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Seq. #:

Machine Or Operation:

Description :

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

IL / mrf 09/04/07

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

09/04/09

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

09-04-09 (5)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

9:00

OVEN TEMPERATURE:

320°

FINISH TIME:

9:30

FD 09/04/09

(5)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

IL

09-04-09 (X5)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

483

9/4/09

5

56

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/14

Job Completion



mrf 09-04-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: H10433
Description: Saddle, Fwd Inboard	Part Number: D2572
Inspection Dwg: D2572 Rev. E	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		.441	.440	.440	.440		
B	1.745	1.755		1.750	1.747	1.747	1.747		
C	3.495	3.505		3.500	3.499	3.498	3.500		
D	1.745	1.755		1.750	1.747	1.747	1.748		
E	7.990	8.010		8.000	8.002	8.001	8.003		
F	0.490	0.510		.497	.498	.500	.499		
G	0.257	0.262		.259	.258	.258	.258		
H	0.375	0.380		.376	.375	.377	.376		
I	0.490	0.510		.502	.508	.508	.506		
J	1.174	1.184		1.179	1.178	1.178	1.178		
K	0.558	0.578		.569	.576	.573	.575		
L	1.174	1.184		1.179	1.178	1.178	1.178		
M	1.490	1.500		1.495	1.495	1.494	1.494		
N	2.495	2.505		2.500	2.499	2.500	2.499		
O	3.869	3.879		3.874	3.874	3.874	3.872		
P	0.115	0.135		.125	.124	.124	.129		
Q	0.115	0.135		.135	.135	.135	.134		
R	0.240	0.260		.250	.250	.251	.251		
S	0.115	0.135		.128	.128	.128	.128		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.960	2.958	2.958	2.959		
V	0.230	0.250		.239	.240	.240	.239		
W	0.115	0.135		.129	.130	.130	.130		
X	0.307	0.312		.310	.312	.313	.312		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.367	.363	.364	.366		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.628	.625	.625	.627		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.245	.242	.250	.250		
AE	1.375	1.395		1.390	1.391	1.392	1.393		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.260	.260	.260	.260		
AH	0.240	0.260		.246	.245	.245	.242		
AI	2.000	2.020		2.005	2.006	2.008	2.003		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	JL
Date:	09/04/05

Audited by:	SP
Date:	09/01/09

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD		Work Order: 46433
Description: Saddle, Fwd Inboard		Part Number: D2572
Inspection Dwg: D2572 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1 5	2 6	3 7	4 8		
A	0.438	0.443		.440					
B	1.745	1.755		1.746					
C	3.495	3.505		3.496					
D	1.745	1.755		1.746					
E	7.990	8.010		8.003					
F	0.490	0.510		.500					
G	0.257	0.262		.258	.258				
H	0.375	0.380		.377	.378				
I	0.490	0.510		.507	.506				
J	1.174	1.184		1.177	1.178				
K	0.558	0.578		.575	.573				
L	1.174	1.184		1.178	1.178				
M	1.490	1.500		1.497	1.495				
N	2.495	2.505		2.498	2.500				
O	3.869	3.879		3.870	3.871				
P	0.115	0.135		.125	.125				
Q	0.115	0.135		.135	.135				
R	0.240	0.260		.250	.249				
S	0.115	0.135		.130	.129				
T	0.178	0.198		.188	.188				
U	2.940	2.980		2.957	2.958				
V	0.230	0.250		.238	.238				
W	0.115	0.135		.129	.129				
X	0.307	0.312		.312					
Y	0.760	0.765		.760					
Z	0.352	0.372		.362					
AA	0.470	0.530		.500	.500				
AB	0.615	0.635		.627					
AC	0.053	0.073		.063	.063				
AD	0.240	0.260		.250					
AE	1.375	1.395		1.391	1.391	1.391	1.391		
AF	0.115	0.135		.121					
AG	0.240	0.280		.260	.260				
AH	0.240	0.260		.243					
AI	2.000	2.020		2.008	2.005	2.005	2.006		
AJ	0.023	0.043		.033	.033				
Accept/Reject									

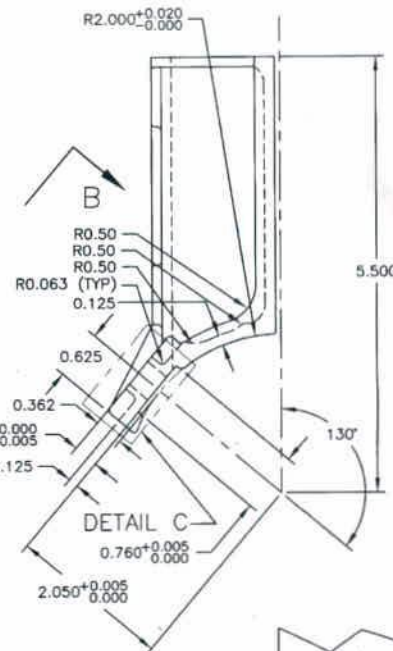
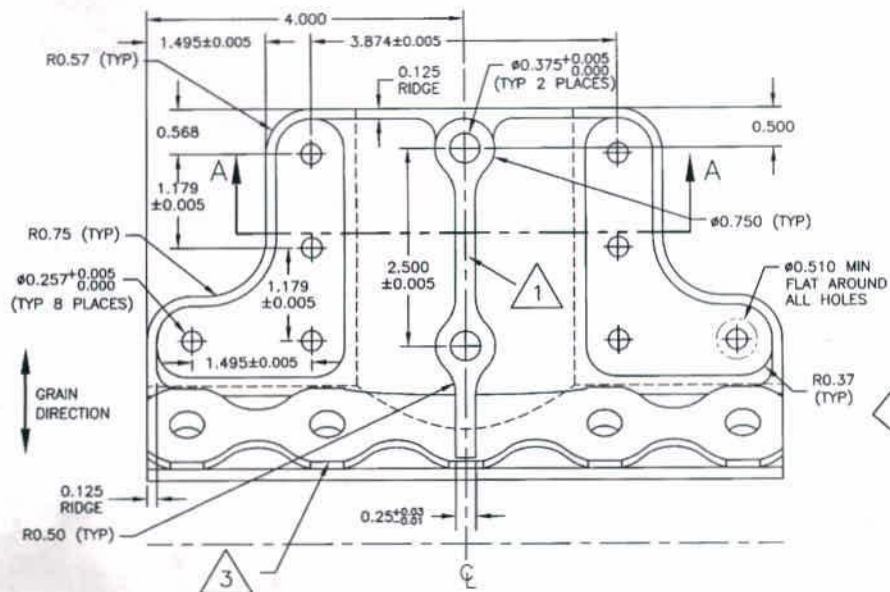
Measured by: <i>mmf</i>
Date: 09/04/08

Audited by: <i>SP</i>
Date: 09/04/09

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

RELEASED

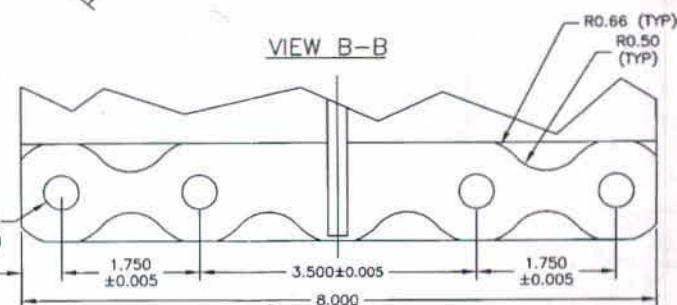
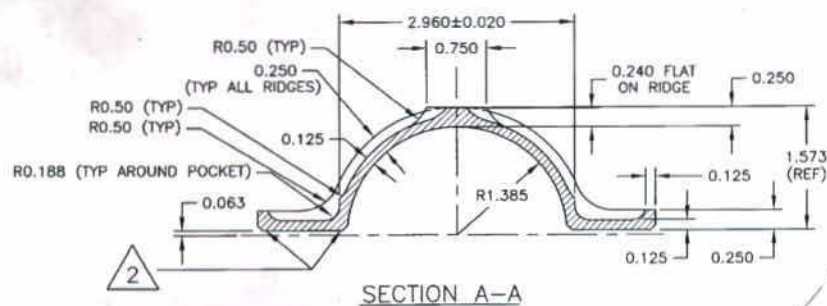
05.12.06



NOTES

MATERIAL: 7075-T7351 (QQ-A-250/12)
(REF DART SPEC. D6102-003)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 3 CHAMFER 0.063 x 45° ALL AROUND
- 4 CHAMFER 0.033 x 45° (SEE DETAIL C) E



E	05.07.13	ADD CHAMFER ON RIDGE NOTE 4
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.43B WAS 0.425
A	96.09.16	NEW ISSUE

DESIGN	DS	DRAWN BY	PH	DART	DART AEROSPACE LTD. HAMMERSBURY, ONTARIO, CANADA
CHECKED		APPROVED		DRAWING NO.	D2572
DATE	05.07.13	TITLE	INNER FWD SADDLE		

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REV. E
SHEET 1 OF 1
SCALE 2:3